

**ATP
Tooling Kit**

**Application Tooling
Specification Sheet**

Order No. 19027-0019

SCOPE

Tooling: ATP Tooling Kits used with Molex Air Tape Press: (ATP 100 and 300 series) or a Molex Mylar Tape Applicator (MTA series). Refer to the appropriate tool instruction manual for installation and operation information.

Products: Avikrimp™ Quick Disconnect Terminal 10-12 AWG. Refer to the Product part number charts on this sheet for terminals with the barrel and tongue styles listed above.

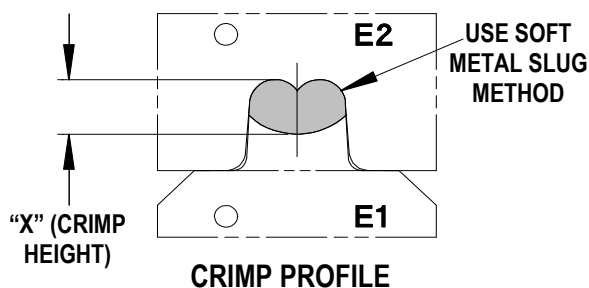
Testing

Mechanical

The tensile test or pull test is a means of evaluating the mechanical properties of the crimped connections. The following charts show the UL Specifications for various wire sizes. The tensile strength is shown in pounds and indicates the minimum acceptable force to break or separate terminal from the conductor.

Color Code	Wire Size (AWG)	*UL - 310
Yellow	10	80
Yellow	12	70

*UL – 310 –Quick Disconnects, Flags, and Couplers



Use soft metal slug (solder) method to measure the "X" dimension. Verify tooling crimp height calibration by referring to the Go/No Go dimensions shown in the chart below.

Molex does not sell gauge pins contact your local industrial supplier.

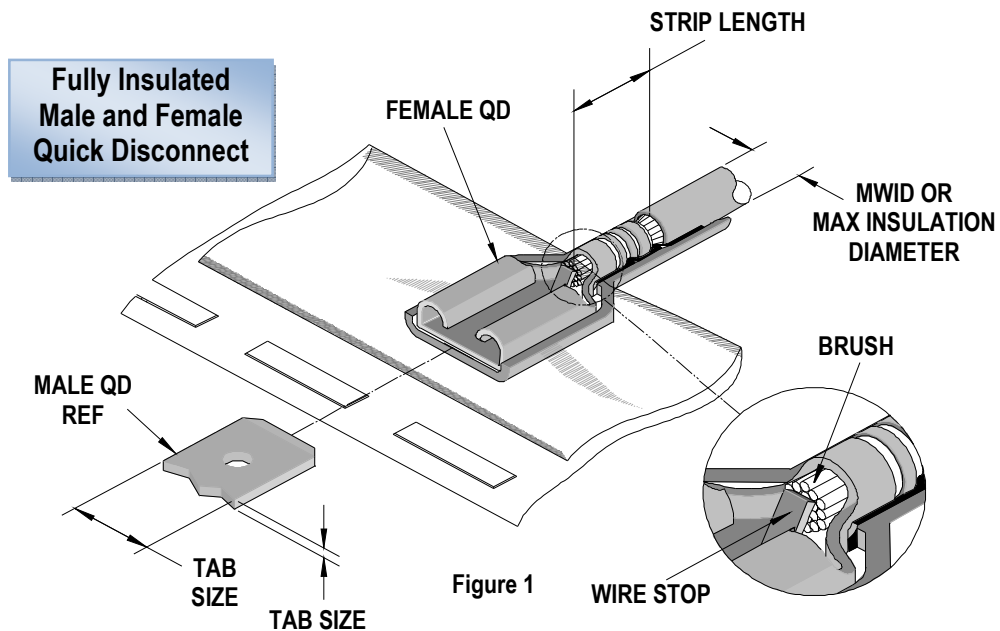
Wire Range		"X" Dimension Conductor Crimp						Crimp Inspection Marking
		Mean		Go		No Go		
AWG	mm ²	In	mm	In	mm	In	mm	
10 - 12	5.00 - 3.30	.100	2.54	.098	2.49	.102	2.59	N/A

The following is a Partial List of the Product Part Numbers and their specifications that this tooling is designed to crimp. We will be adding to this list and an up to date copy is available on www.molex.com.

Wire Size: 10 – 12 AWG 5.00 – 3.30mm ²					
Terminal No.	Terminal Eng No. (REF)	Wire Strip Length		Insulation Diameter Maximum	
		In	mm	In	mm
19606-0006	19606-0006	.343	8.73	.230	5.84
19277-0009	C-5293T-LIF	.343	8.73	.233	5.92

DEFINITION OF TERMS

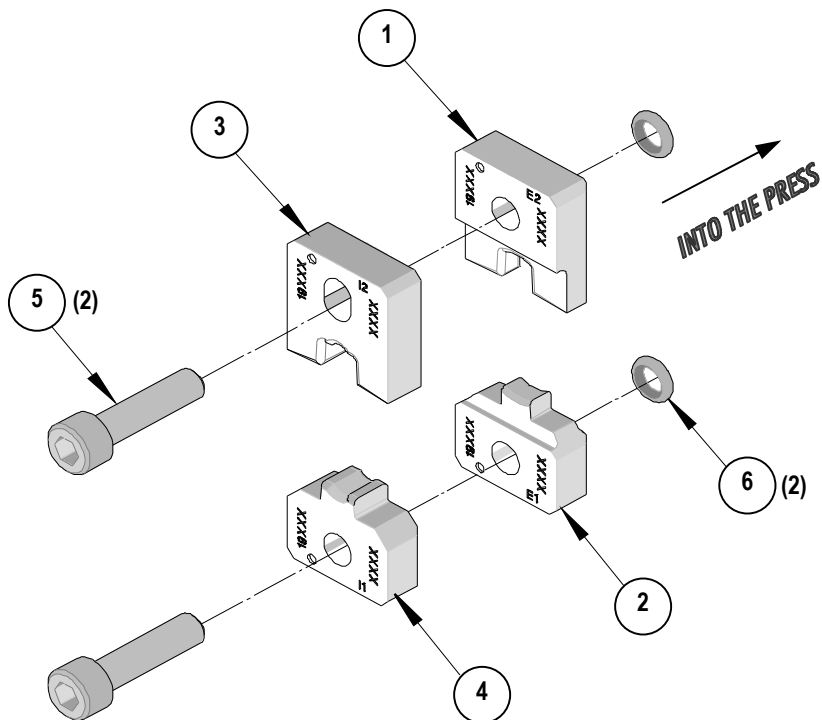
The following illustrations are a generic terminal representation and not an exact image of any terminal listed in the scope.



Parts List

Item	Order No.	Engineering No.	Description	Qty
	19027-0019	19027-0019	ATP Tooling Kit	REF
1	19027-0020	19027-0020	Conductor Punch	1
2	19027-0021	19027-0021	Conductor Anvil	1
3	19027-0022	19027-0022	Insulation Punch	1
4	19027-0023	19027-0023	Insulation Anvil	1
5	N/A	N/A	#10-32 by 7/8" Long SHCS	2**
6	N/A	N/A	O-ring 1/16 W. by 9/32" O.D.	2**

** Available from an industrial supply company such as MSC (1-800-645-7270).



Visit our Web site at <http://www.molex.com>